

Work Order ID 83069-1

83069

Page 1

Item ID: D3565-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 12/04/2012 Start Qty: 9.00

Q

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 9.00

Q

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 12/04/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3565

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3565 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

364. QG2

B12-5-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-24

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/12/05/29

110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83069

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83069

Page 2

Item ID: D3565-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 12/04/2012 Start Qty: 9.00

9

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 9.00

9

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Large Fab

5

0

12-10-22
JBL

Large Fab

Memo

0.00

1-Weld D3009-3 cups as per dwg D35652-Weld hard facing as per Dwg
D3565 using DT8991 jig A/R 2059B Hard Coat rod
Batch: ~~1123215~~ M123215

SS. 304 - M122357

140

0.00

140

QC9- Inspect visual per QSI004- Fusion Welds

DAS
24
2-89

12.10.22

5x

QC

Memo

0.00

Quality Control

150

0.00

150

QC5- Inspect part completeness to step on W/O

5mD

5

QC

Memo

0.00

Quality Control

12.10.23

W/O:		WORK ORDER CHANGES					
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Work Order ID 83069

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8.3069

Page 3

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Setup Start

NS1

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NS2

Item Name: Wearplate

Start Date: 12/04/2012 Start Qty: 9.00

9

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 9.00

9

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

m122966

11:40
3200
12:10

5x

m-f
12/10/23

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

5

12-10-23

180

Identify as per dwg & Stock Location: ST500

0.00

180

Packaging

Memo

0.00

Packaging

5

12/10/23

W/O:		WORK ORDER CHANGES					
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Item Name: Wearplate

Start Date: 12/04/2012 Start Qty: 9.00

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Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 9.00

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Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

12/10/24 

12-10-24

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 83069

83069

Parent Item: D3565-1

D3565-1

Parent Item Name: Wearplate

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 9.00

Required Qty: 9.00

Comments:

IPP Rev:A New Issue 07-01-16 JLM
 IPP rev B revB dwg 07.04.18 cc
 IPP Rev:C rev.c as per dwg 08-01-14 DD verified by:
 IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3009-3		Manufactured	No			100	Each	32.0000	3	27			
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D3009-3

Cup

**

12-10-22
JBL

Location

WA

88386

Loc Qty

30

Loc Code

15

79078

2

80095

M304S16GA

Purchased

No

130

sf

239.8520

0.135

1.278947

**

12-5-24

M304S16GA

304/316 Sheet .063

Location

MAT020

120866

120877

121070

Loc Qty

239.852

38.446

137.326

64.08

Loc Code

121626

121626

10

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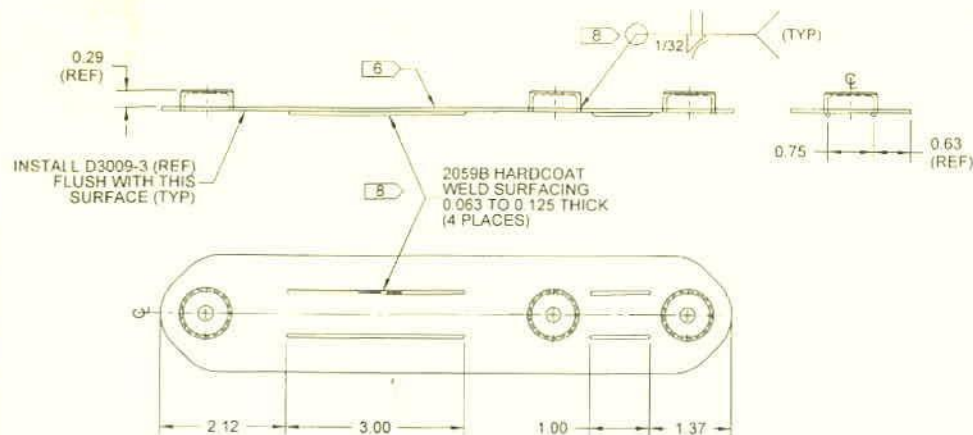
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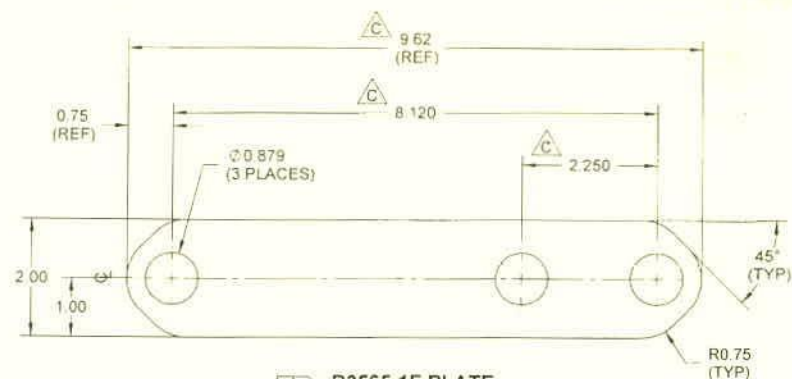
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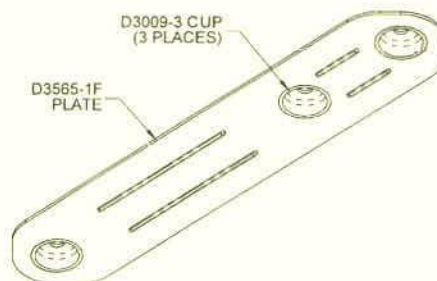
NOTE: Date & initial all entries



D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

QTY -1	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT Q

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83069 MLC 12/04/13

RELEASED
06-01-11/12

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220; 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	M/B	07.12.14
H	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	JP		
CHECKED	JP		
MFG APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3565** REV. C
SHEET 1 OF 1
TITLE **R44 WEARPLATE** SCALE 1:2

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